

Work Order ID 162948

Friday, June 16, 2017 12:31:24 PM

162948

Page 1

Item ID: D2746 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 6/16/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/26/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUN 16 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2746	Rev C								

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D2746 Dwg Rev: C Prog Rev: C 2-
 Deburr if necessary

0.44

SC 17/06/24

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

SC 17/06/24 117-06-2

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

4 DAS 38 9-89
 JUN 26 2017

Friday, June 16, 2017 12:31:24 PM

Page 2

JUN 27 2017
JUN 27 2017

Work Order ID 162948

Friday, June 16, 2017 12:31:24 PM

162948

Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>11 B6870</i> Memo START TIME: <i>9:05</i> OVEN TEMPERATURE: <i>220</i> FINISH TIME: <i>9:35</i>	0.00 0.26				<i>4</i>	<i>0</i>	<i>17073</i>	<i>33</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>4</i>			<i>DAS 38 9-89</i> <i>JUL 03 2017</i>
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST190</i> Memo	0.00 0.00				<i>4</i>	<i>DAS 28 9-89</i>	<i>JUL 03 2017</i>	

Work Order ID 162948

Friday, June 16, 2017 12:31:24 PM

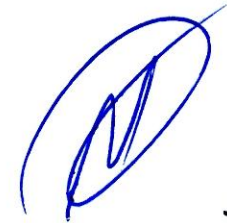
162948

Page 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									



JUL 03 2017

Picklist Print

Friday, June 16, 2017 12:31:42 PM

Page 1

Work Order ID: 162948

162948

Parent Item: D2746

D2746

Parent Item Name: Wearplate

Start Date: 6/16/2017

Required Date: 6/26/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: D02.10.24Re-formatKJ
IPP Rev: E 06-03-21 as Per Rev C JLM
IPP Rev: F 06-06-12 Now On Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased		No		110	sf	99.2084	0.406	1.709474			
M1010S20GA									**				
1010/1025 SHEET													

Location

MAT019

m130805

Loc Qty

99.2084

99.2084

Loc Code

1.8

SC 17/06/24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD		Work Order:	162988
Description: Wearshoe		Part Number:	D2746
Inspection Dwg: D2746	Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	<i>SC</i>	Audited by:	<i>DAS</i>	Prototype Approval:	N/A
Date:	<i>17/07/24</i>	Date:	<i>30/07/24</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	

DART

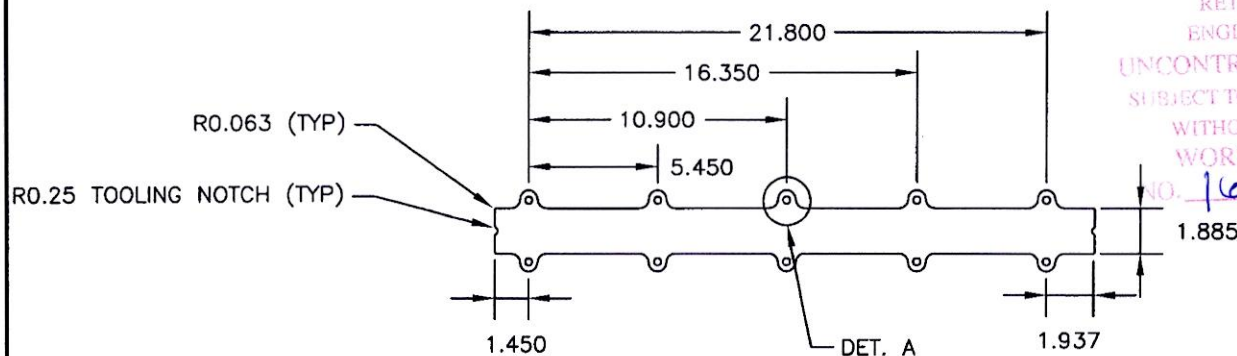
RELEASED
06-22-07

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

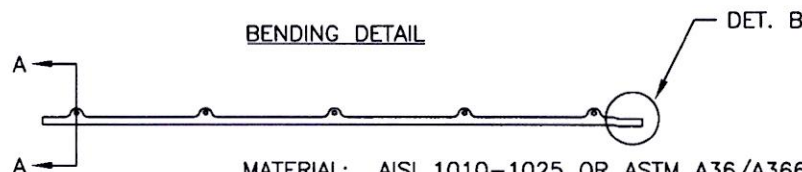
NO. 162948
MLJ
17-06-16

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHKD <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2746	SHEET 1 OF 1	SCALE 1:8
DATE 06.01.12	TITLE WEARSHOE			
A	98.04.16	NEW ISSUE		
B	98.08.18	RE-DESIGN		
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT		

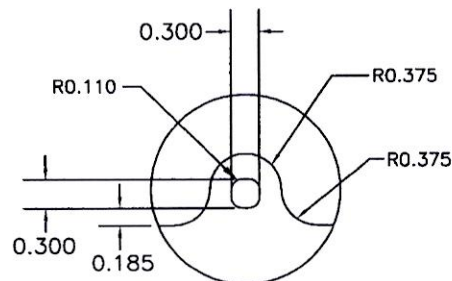
FLAT PATTERN



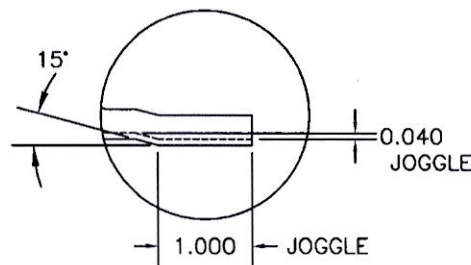
BENDING DETAIL



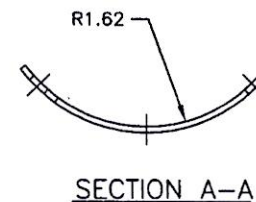
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)



DETAIL A



DETAIL B



SECTION A-A

NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21